

Work Order ID 151997

Monday, October 17, 2016 10:06:49 AM

151997

Page 1

Item ID: D3882-1-130 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Extrusion "I" Beam
Start Date: 10/17/2016 Start Qty: 65.00 ***65*** Cust Item ID:
Required Date: 10/28/2016 Req'd Qty: 65.00 ***65*** Customer:
Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3882	Rev A								

100

0.00

100

Purchasing

Purchasing

Memo

PURCHASING

Issue P/O: 33998

a) Extrude as per Dwg D3882

b) Material: 6061-T6 (QQ-A-200/8) OR ASTM B221

c) Minimum yield tensile strength = 35 ksi

d) Minimum ultimate tensile strength = 38 ksi

e) Minimum elongation = 8%

f) Order at 130" long

g) Bon L Canada Inc. tool #DAA-6

H Pull test to ASTM standard B221 required.

J) Material certification is required

***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE
SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH
AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS,
OR DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

65OCT 19 2016**DAS**
13
9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.22							
Packaging	ENSURE C OF C IS ATTACH								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.11							
Packaging	LOCATION : LG002								

70X Sp/6-11/16

70 16-11-17 DAS 9 9-89

Will ship to Wjog
 CL16110119

70 16-11-17

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	1.08							
Quality Control									

DAS
21
9-59
NOV 18 2016

16.11.18

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D3882-1-130

Required Date: 10/28/2016

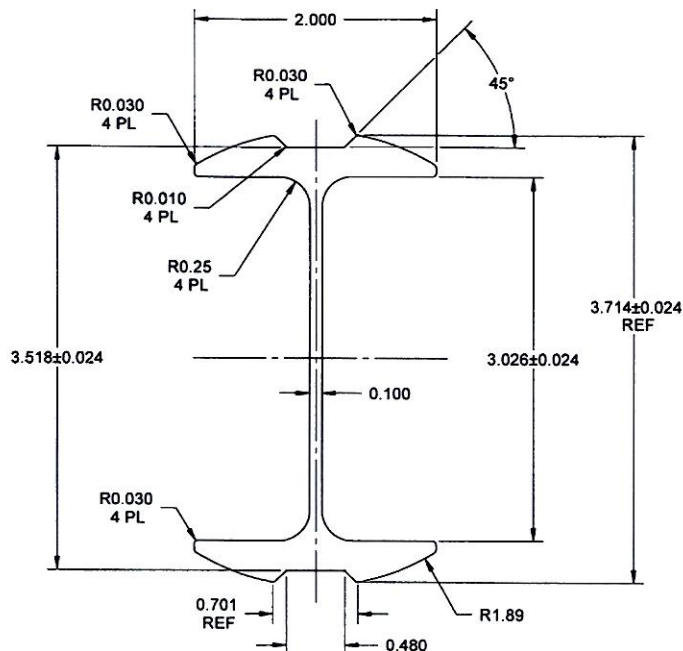
Required Qty: 65.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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0.0000

65

EXTRUSION



GENERAL NOTES:

1) MATERIAL: 6061-T6 PER QQ-A-200/8 OR ASTM B221
 MINIMUM TENSILE YIELD STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
 MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO
 ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY
 TO ENSURE THAT THE BATCH MEETS THE ABOVE
 MINIMUM MECHANICAL PROPERTIES

2) BREAK ALL SHARP CORNERS 0.010 MAX

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

5) PART NUMBER IS D3882-1-XXX WHERE XXX IS
 CUT LENGTH IN INCHES (EX. D3882-1-180 IS 180" LONG)

6) D3882-1 EXTRUSION MANUFACTURED FROM: DIE # DAA-6

D3882-1 EXTRUSION

RELEASED
 09/01/23

A		NEW ISSUE		RF	09.01.23
REV.	DESCRIPTION	BY	DATE		
DESIGN	RF				
DRAWN	RF				
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE	09.01.23				
DART AEROSPACE USA, INC.					
PORT HADLOCK, WA					
DRAWING NO.				REV. A	
D3882				SHEET 1 OF 1	
TITLE				SCALE	
EXTRUSION				NTS	
COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.					
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO33998

Purchase Order Date 10/19/2016 1:33:54 PM
PO Print Date 10/20/2016

Page Number 1 of 2

Order From :

VC-BON001

SIGNATURE ALUMINUM CANADA INC.
C/O/ T10322C
P.O. BOX 4488, STN A
TORONTO, ON M5W 4H1
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

REVISED \$

Contact Name

Vendor Phone 905-427-6550

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3882-1-130P ✓ EXTRUDE A SPER DWG D3882 REV. A B151997 EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.***	EXTRUSION	11/16/2016 Yes 11/16/2016		65.00 Each	\$37.21	\$2,418.39
						Line Total:	\$2,418.39
2	71401-45 Procurement Quality Clause Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents		11/16/2016 No 11/16/2016		1.00	\$0.00	\$0.00

recu FOX

SP16-11-16

Note:

10/20/2016



ACCT# 46024

1850 Clements Road, Pickering Ontario, Canada L1W 3R8 INVOICING AND COMPANY LOCATION

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealum.comSIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST

PACKING LIST DATE / DATE DU
11-15-16PACKING LIST NUMBER / N° DE
029115SALES ORDER NUMBER / N° DE COM
125477

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCEREFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

LOCATION	TRAILER NUMBER / REMORQUE Nombre	SALESMAN / VENDEUR	CREDIT REP / REP DU CRÉDIT	SALES REP / REP. DES VENTES
PIC	222407	042		R. BLAIS
JOB / FICHIER		FIELD SALES REP / REP REGIONAL DES VENTES		CUST SERVICE REP / REP. SERVICE CLIENTELE
MCGILLION		G.ATTENBOROU		M2A

CUSTOMER ID / ID DU CLIENT		ORDER DATE / DE LA COM		CUSTOMER PO NUMBER / CLIENT PO Nombre			JOB / FICHIER		FIELD SALES REP / REP REGIONAL DES VENTES		CUST SERVICE REP / REP. SERVICE CLIENTELE	
46024		10/19/16		PO33998								
BILL OF LADING NUMBER / NO. DE CONNAISSEMENT							CARRIER / TRANSPORTEUR		G.ATTENBOROU		M2A	
029115							MCGILLION					
ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison	
				CUSTOMER PART NUMBER / NUMÉRO DE RÉFÉRENCE DU CLIENT	LENGTH / LONGUEUR	ABRICATION DESCRIPTION / DESCRIPTION DE FABRICATION						
					CUTTING TOLERANCE / Tolérance de coupe	SHIPPING TOLERANCE / EXPÉDITION TOLERANCE						
001	1,141	LB		DAA-6-1	6061 T6		1	1,202	1,171	LB		
	517	KG		D3882-1-130P	130.0000 IN			545	531	KG		
Y	65	PC			Cut(+): 0.1180	Cut(-): 0.0000	Min: -10 %	Max: 10 %		70	PC	
							873013 / 341622	1	1,202	1,171	70 PC	

S216-11-16

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the specifications set of 1992 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

Page 1 of 1

1	1,202	1,171	LB
	545	531	KG
		70	PC
TOTALS			

DATE OF DELIVERY

DRIVER

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
11/14/2016	5407197	125477	1
Cust PO	B/L No	Lot	Date
PO33998	029115	873013	11/15/16

Sold To			Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA			46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA
Item No	Part No	Item Description	Cust Part
001	DAA-6-1	130" MILL 6061 T6	D3882-1-130P
Gross Weight	1,202 LBS		
Net Qty	1,171 LBS 70 PCS 1 PKGS		
Specification		Die Desc	
ASTM B221-13			

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HRE
308.3 / 44.7	289.0 / 41.9	11.7	N/A	95

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.62	0.27	0.21	0.04	0.88	0.08	0.05	0.01	0.01	0.00

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com